

Date: Tuesday, 10/23/2007 3:10:29 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	HEATER BRACKET	
Job Number	35323				
Estimate Number	12159				
P.O. Number	N/A		Part Number	D2002003	
This Issue	10/23/2007	S.O. No.	Drawing Number	D2002 REV C	
Prsht Rev.	NC		Project Number	N/A	
First Issue	N/A		Drawing Revision	C	
Previous Run	28129		Material	N/A	
Written By			Due Date	11/15/2007	Qty: 10 Um: Each
Checked & Approved By	10/23/2007				
Comment	Est. B 99.05.21 Re-format, Made in house DM Est Rev:C Now on Waterjet 06-08-14 JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M2024T3S063	2024-T3 .063 sheet  4,4913
		Comment: Qty.: 0.4083 sf(s)/Unit Total : 1.6334 sf(s) 2024-T3 .063 sheet Material: 2024-T3, 0.063" Thick Batch 102942 4B07-11-8 • M+386 104677
2.0	WATER JET	FLOW WATER JET  
		Comment: FLOW WATER JET 1-Cut as per Dwg D2002-003 Dwg Rev: C 4B07-11-8 Prog Rev: C  2-Deburr if necessary
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE   4B07-11-8
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK   S 4/11/09 (X) 11 counter
		Comment: SECOND CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1  
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Countersink holes as per Dwg D2002-003 Deburr  MF 07-11-26

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/11/28  
 QA: N/C Closed:  Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/11/19	5	( piece crack at the bend  R.C. setup. (first part)	<u>DS</u> <u>07/11/19</u>	Scrap & destroy	8B 07/11/19	<input checked="" type="checkbox"/>	<u>DS</u> <u>07/11/26</u>	<u>DS</u> <u>07/11/26</u>
07/11- 08/06	5.	1 piece, counter sink hole too big.  R.C. thinner an error	<u>DS</u> <u>07/11/19</u>	Scrap & destroy	MF 07-11- 26	<input checked="" type="checkbox"/> <u>DS</u> <u>07/11/26</u>	<u>DS</u> <u>07/11/26</u>	<u>DS</u> <u>07/11/26</u>

NOTE: Date & initial all entries

Date: Tuesday, 10/23/2007 3:10:29 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HEATER BRACKET

Job Number: 35323

Part Number: D2002003

Job Number:



Seq. #: Machine Or Operation:

Description :

Form as per Dwg D2002-003

SB 07/11/19

6.0 QC5

INSPECT WORK TO CURRENT STEP



S 07/11/26 (P) (QX)

Comment: INSPECT WORK TO CURRENT STEP

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



S 07/11/26 (P) (QX)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-L 07/11/27

8.0 POWDER COATING

POWDER COATING



m 102316 (QX)

Comment: PURCHASING

Powder Coat Black Crinkle (Ref. 4.3.5.3)as per QSI 005 4.3

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



F-L 07/11/27 (QX)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0 PACKAGING 1

PACKAGING RESOURCE #1



m 07/11/27 (QX)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST166

(W)

B 07/11/28

(QX)

11.0 QC21

FINAL INSPECTION/W/O RELEASE



(Q)

Comment: FINAL INSPECTION/W/O RELEASE

D 07/11/28

Job Completion



W 07/11/28

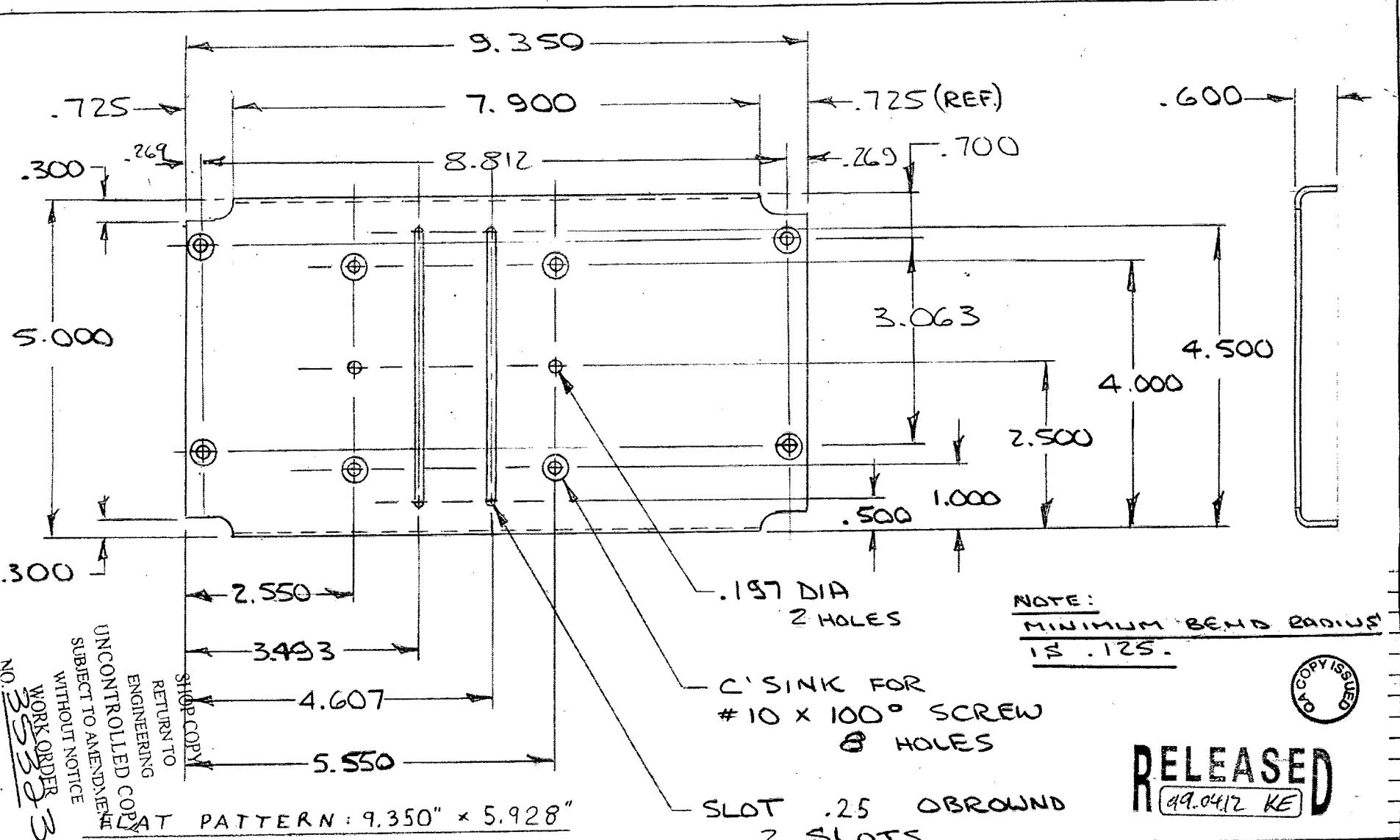
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**SHOP COPY**  
RETURN TO  
ENGINEERING  
**JN CONTROLLED COPY**  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER NO. 35323 AT P

T PATTERN: 9.350" x 5.928"

C	B	A
RE	JB	JB
12/12/12	12/1/12	9-1-10
025 WAS 0.00		
SLOT DIM		
ABOVE D		
MTC HOLES		
	REDRAWN -	
	TRANSFER TO	
	SMALL UNIT	

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REVIEW OF THE PUBLICATIONS RECEIVED.

REQUIREMENTS — UNLESS OTHERWISE SPECIFIED

1. DIMENSIONS ARE IN INCHES	1. TOLERANCES - .00X $\pm .000$
2. SURFACE ROUGHNESS $\frac{1}{16}$	.00X $\pm .010$
3. REMOVE SHARP EDGES .015 MAX	.01
4. THREADS PER MIL .5 - 7742	.0025
5. HOLES PER AHD 10367	.005 MAX

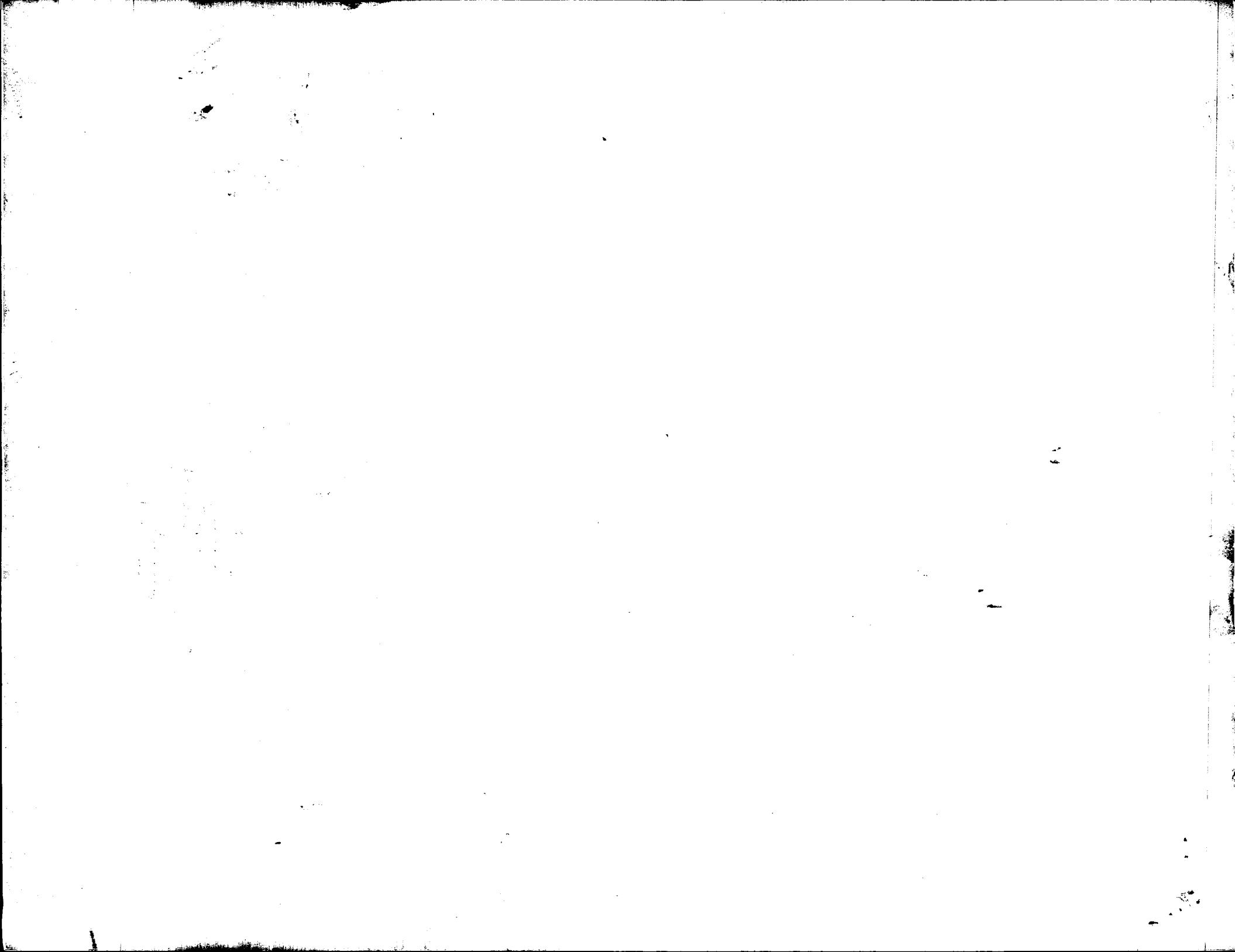
**REPORT ALL DISCREPANCIES — DO NOT SCALE**

RIVET CODE SHALL BE PER NAS 523		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR
BASIC CODE  D=DIMPLE D+H=NO. OF SHEETS C=COUNTERSINK	DIA. DASH NO. B=FLAT HEAD SIDE P=HEAD FAR SIDE	CONTRACT NO.		DART AERO ACCESSORIES INC. VANCOUVER CANADA		
BASIC CODES  82-MS2047040 85-MS2042640	LENGTH DASH NO. W=SPOT WELD	DRAWN BRADLEY	DATE 9/1/10			
	DESIGN BRADLEY	9/1/10	TITLE			
	STRESS		BRACKET			
	CHECKED		CODE YU	DWC NO. D 200Z-003	REV. C	
	CURENT		SCALE 1:2	SHT 1 OF 1		
OT SCALE						

RELEASED  
09-04-12 KE



NOTE:  
MINIMUM BEND RADIUS  
IS .125.



DART AEROSPACE LTD	Work Order:	35323
Description: HEATER BRACKET	Part Number:	2002003
Inspection Dwg: D2002003 Rev: C		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## First Article      Prototype

Measured by:	B	Audited by:	C	Prototype Approval:	✓
Date:	07-11-8	Date:	27/1/09	Date:	27/1/09

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	